

Date: Friday, 23/05/2008 9:56:51 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FRAME WELDMENT
<b>Job Number</b> :	39446		
<b>Estimate Number</b> :	11202		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3330041
<b>This Issue</b> :	23/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3330 REV D
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	37640	<b>Drawing Revision</b> :	D
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	30/06/2008
<b>Written By</b> :		<b>Qty:</b>	4 Um: Each
<b>Checked &amp; Approved By</b> :	<u>JULIE LECOCQ</u>		
<b>Comment</b> :	Est. A05.01.13 New Issue KJ/JLM est B 07.05.14 revC dwg ec Est C 07.12.19 Rev D ecn1085 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33301	Panel
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1	D3330-1	Panel	<u>B37440</u>
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2.0	D33302	Panel
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1	D3330-2	Panel	<u>B37441</u>
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3.0	D33303	Panel
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1	D3330-3	Panel	<u>B35487</u>
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4.0	D33305	Panel
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rail

Pick:

Qty Part Number Description Batch

			<u>B36011</u>
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08/06/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 23/05/2008 9:56:52 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 39446

Part Number: D3330041

Job Number:



Seq. #: Machine Or Operation: Description :

1 D3330-5 Panel

5.0 D33307 Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1 D3330-7 Panel B37081

LS

6.0 D33309 Top Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Top Plate

Pick:

Qty Part Number Description Batch

1 D3330-9 Panel B35488

LS

7.0 D333011 Long Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Long Pin Bracket

Pick:

Qty Part Number Description Batch

1 D3330-11 Long Pin Bracket B39321

LS

8.0 D333013 Short Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Short Pin Bracket

Pick:

Qty Part Number Description Batch

1 D3330-13 Short Pin Bracket B37079

LS

9.0 D333015 Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch

1 D3330-15 Handle B37080

LS 08/06/02

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 39446

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D333017

Handle Socket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Handle Socket

Pick:

Qty Part Number Description Batch

1 D3330-17 Handle Socket **B39460**

*JS*

11.0

D333019

Handle Rim



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Handle Rim

Pick:

Qty Part Number Description Batch

1 D3330-19 Handle Rim **B30957**

*JS* 08/06/02

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble and Weld as per Dwg Dwg D3330 using D3330-041T1 ✓

Identify as D3330-041 ✓

*JS* 08/06/05

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-06-10 (41)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S* 08/06/10 (44)

15.0

POWDER COATING

POWDER COATING



**M18052**



**(4X)**

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

**8:45 a.m**

OVEN TEMPERATURE:

**320 °F**

FINISH TIME:

**9:15 a.m**

*M/A* 08/06/12

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Drawing Name: FRAME WELDMENT

Job Number: 39446

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/06/12 (4)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 274

AS 08/06/12 (4)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/12 (4)

Job Completion



u 08/06/12

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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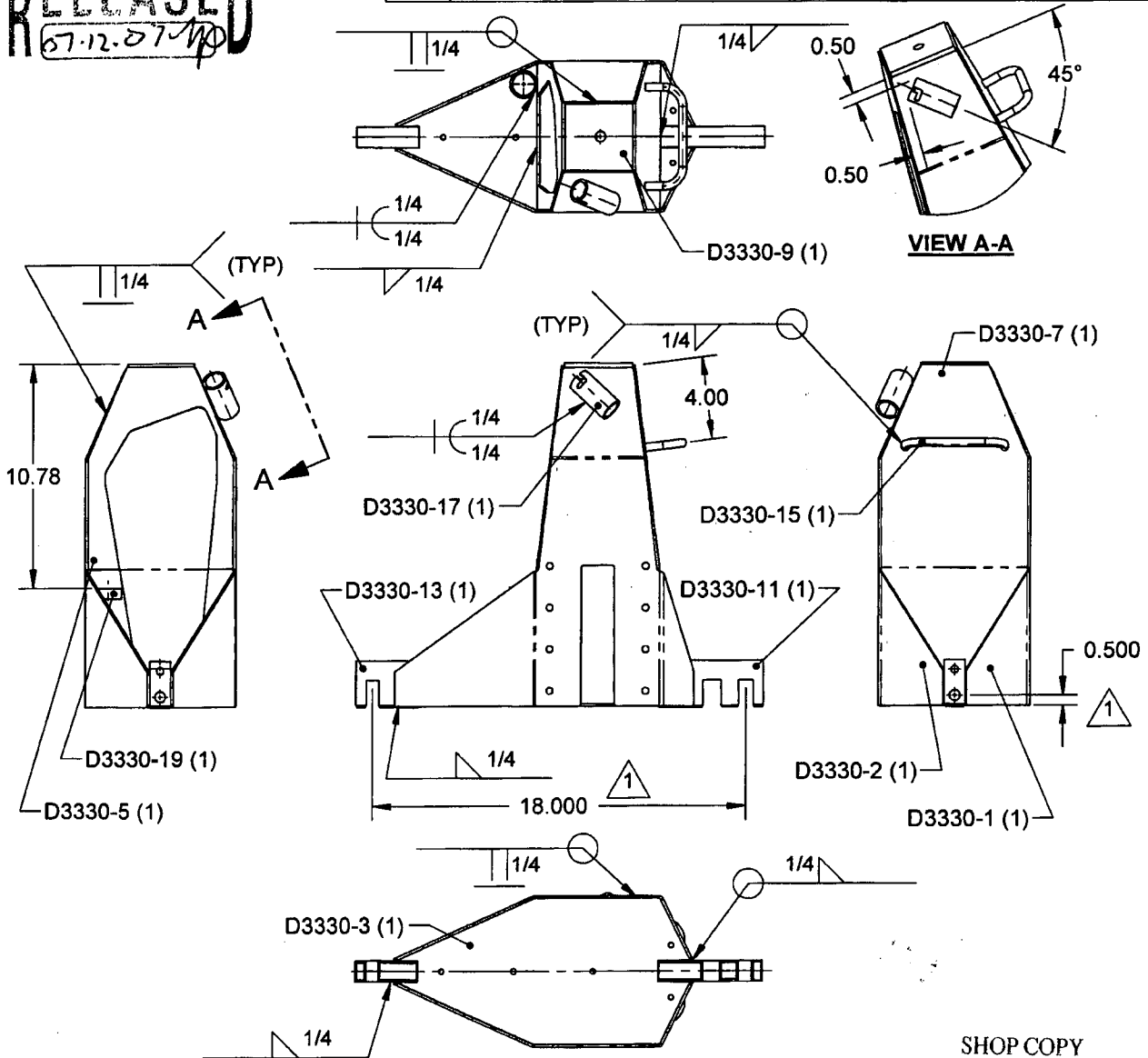
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**DART****RELEASED**  
07.12.07

DESIGN <i>BS</i>	DRAWN BY <i>DC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LS</i>	APPROVED <i>W</i>	DRAWING NO. <b>D3330</b>	REV. D SHEET 1 OF 9
DATE <b>07.12.06</b>		TITLE <b>FRAME WELDMENT</b>	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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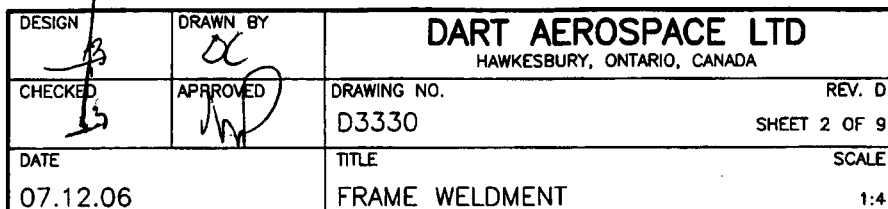
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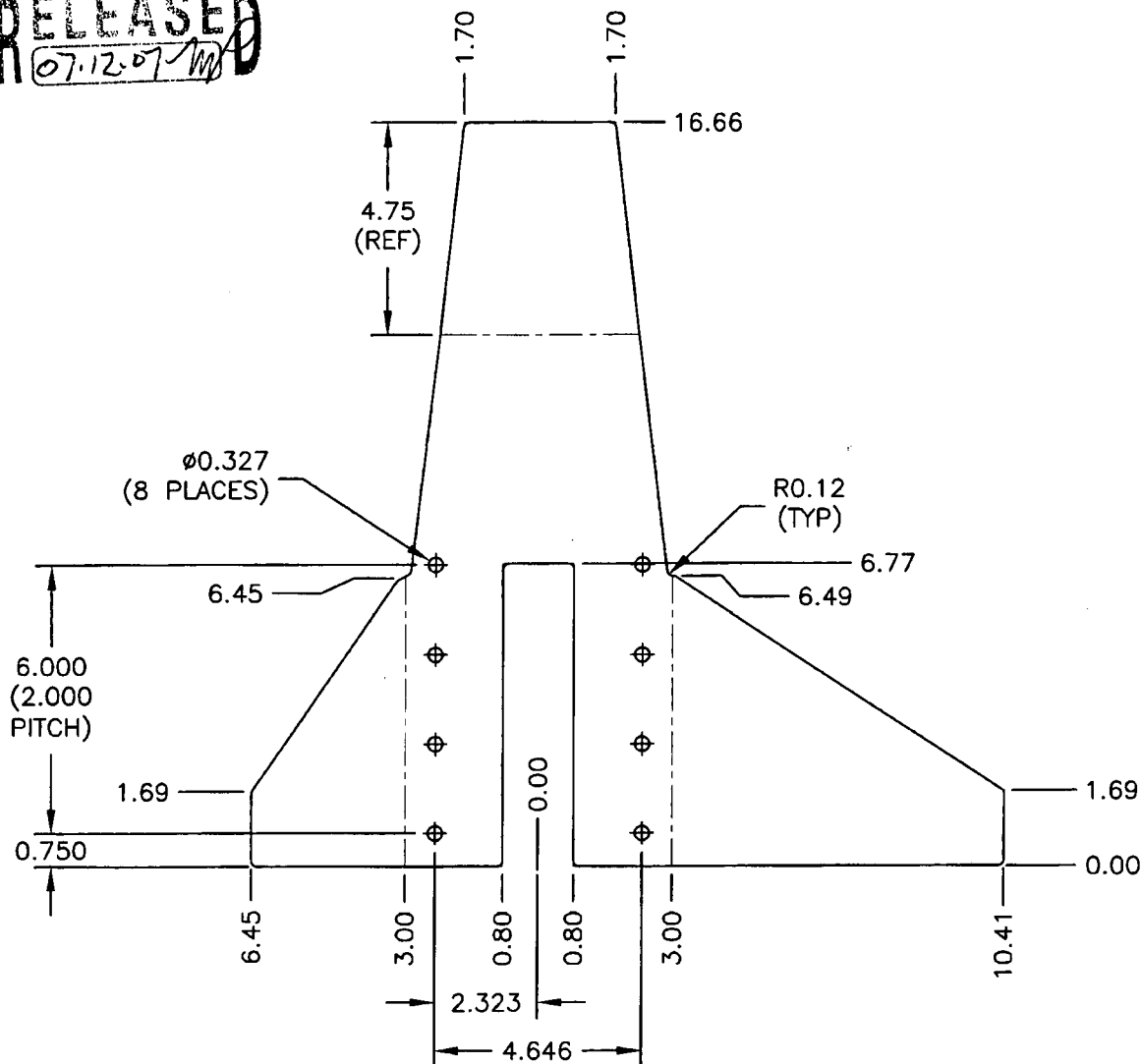
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**NOTE:** Date & initial all entries



RELEASED  
07.12.07



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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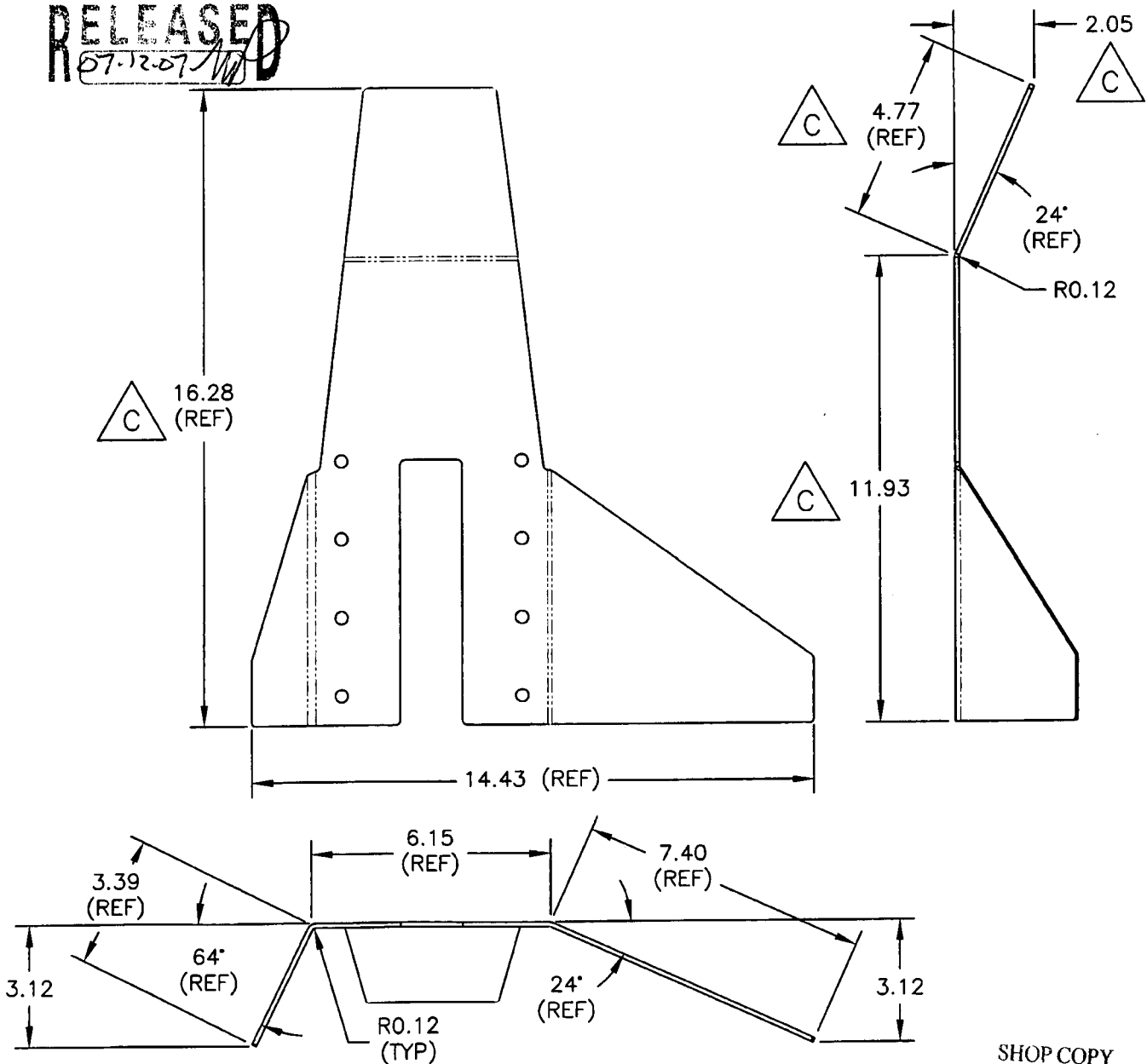
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CHECKED <i>MB</i>	APPROVED <i>MB</i>	DRAWING NO. D3330	REV. D SHEET 3 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

**RELEASED**  
07-12-07**D3330-1 BEND DETAIL (SHOWN)**

BEND D3330-2 (OPPOSITE)

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

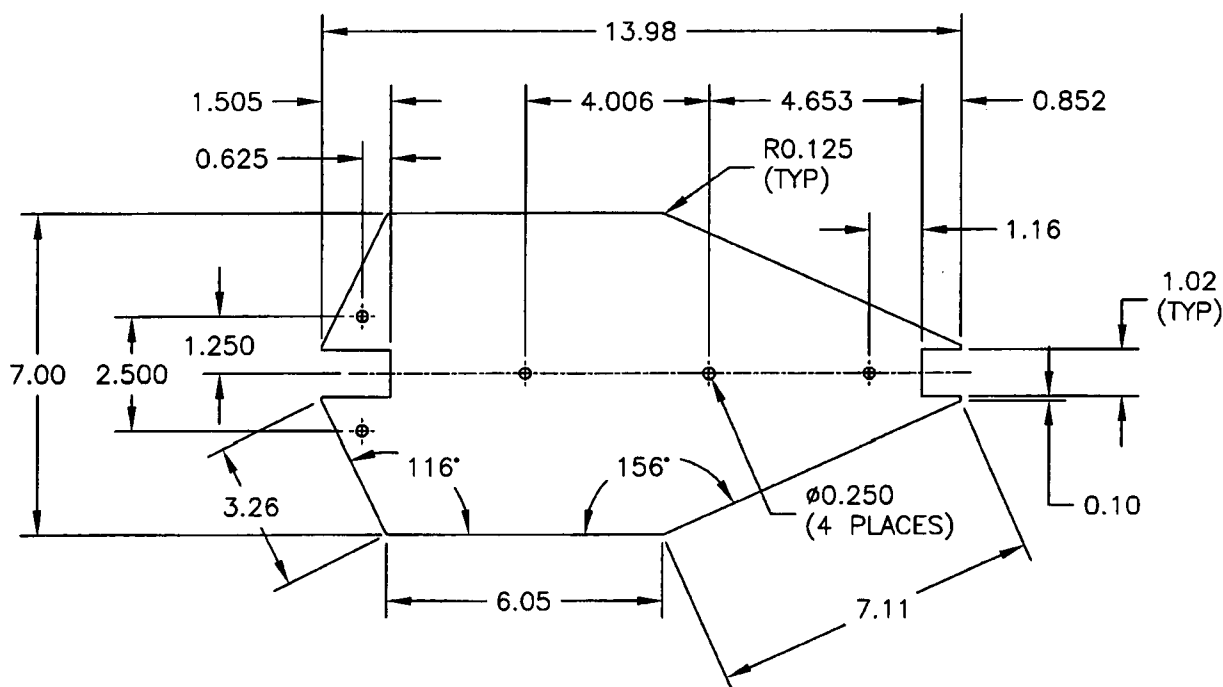
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED  
07.12.07 *[Signature]*



### D3330-3 PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

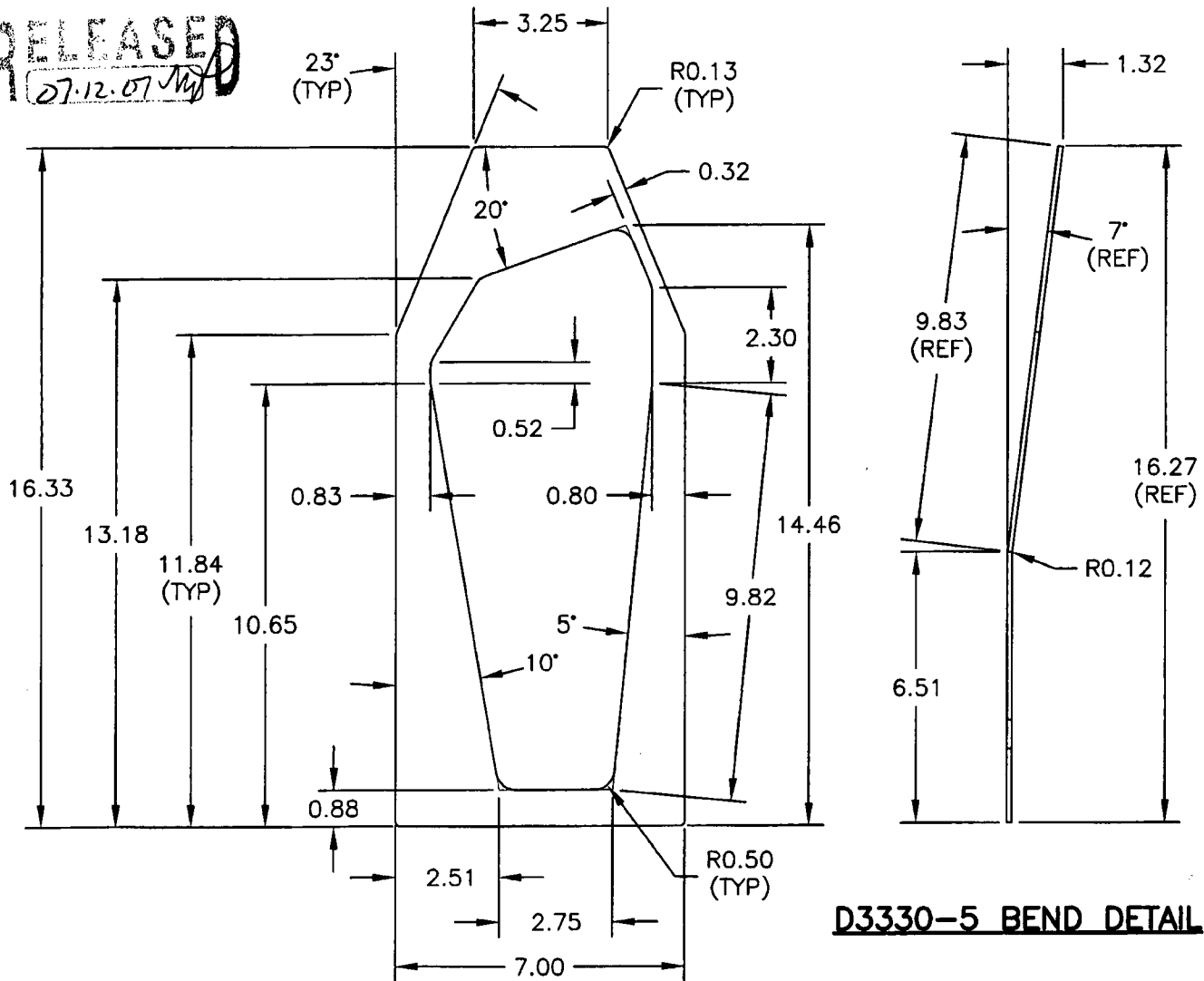
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

**RELEASED**  
07.12.07 *WJ***FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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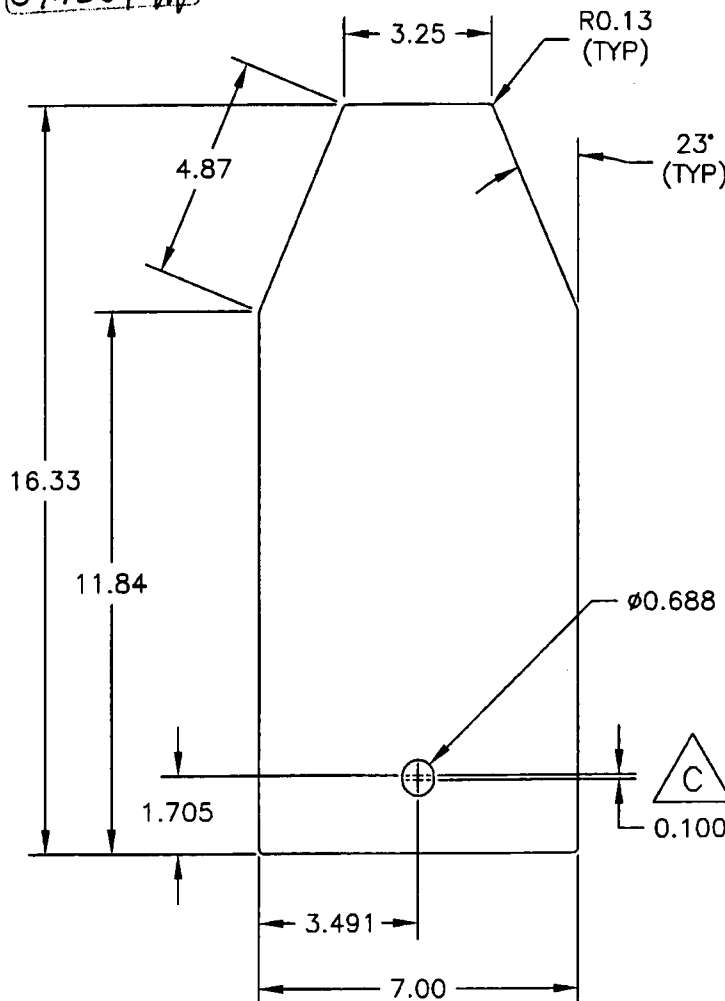
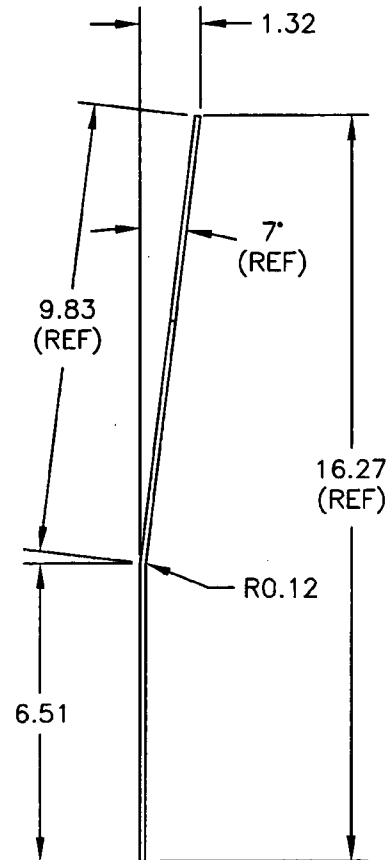
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CHECKED <i>B</i>	APPROVED <i>MP</i>	DRAWING NO. D3330	REV. D SHEET 6 OF 9
DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

**RELEASED**  
07.12.07 *MP***FLAT PATTERN****D3330-7 BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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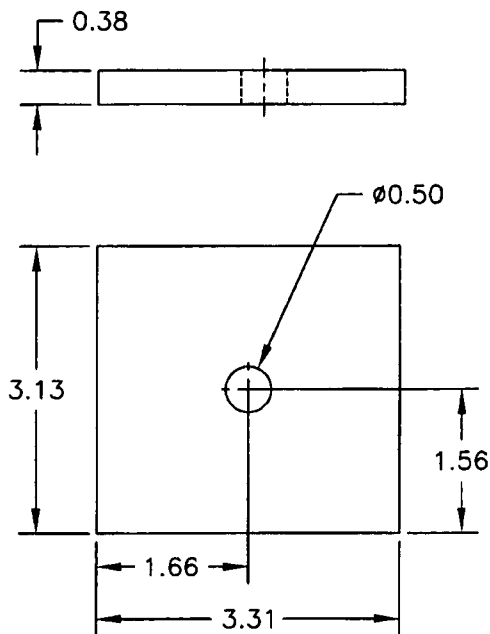
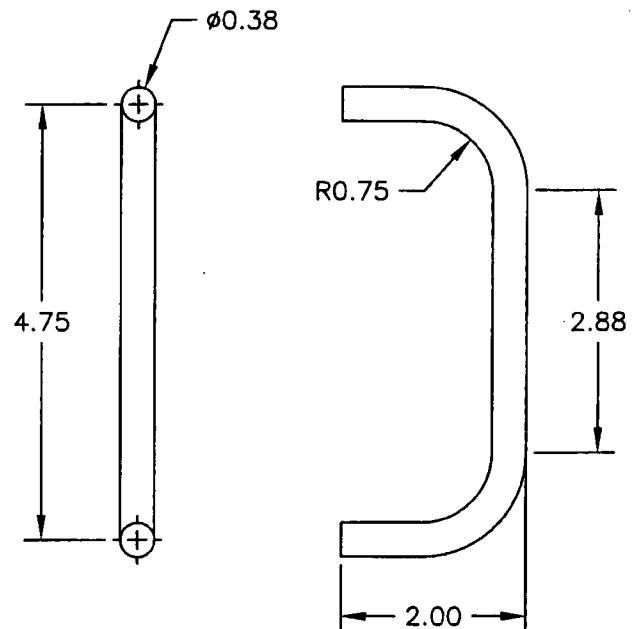
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3330	REV. D SHEET 7 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

RELEASED  
07.12.07**1 D3330-9 TOP PLATE****2 D3330-15 HANDLE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL  
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097  
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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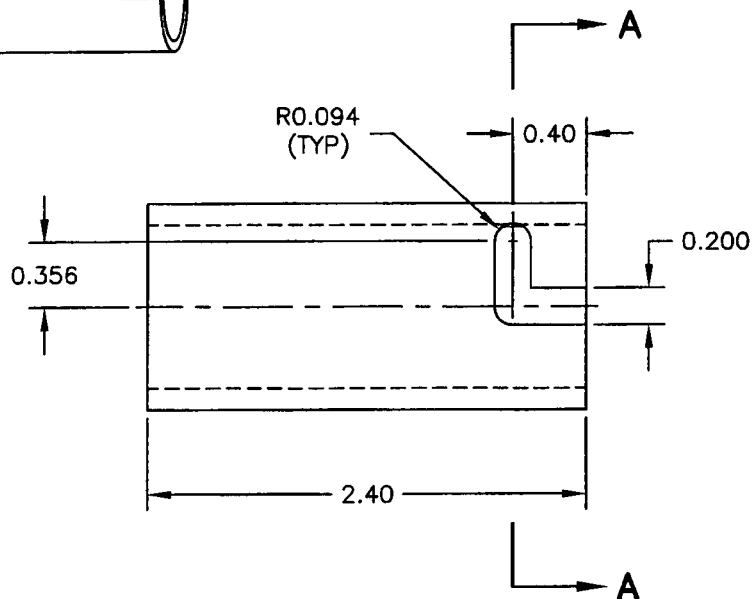
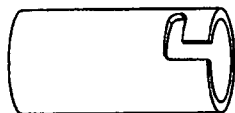
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

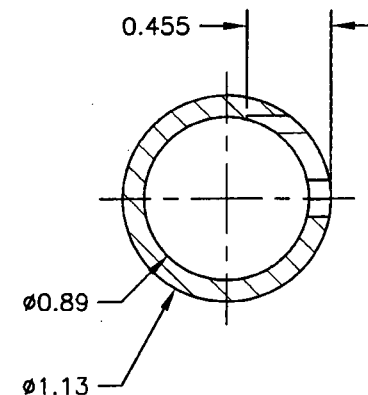
**NOTE:** Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>MP</i>	DRAWING NO. D3330	REV. 0 SHEET 8 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:1

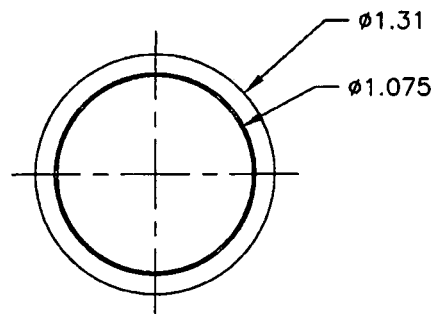
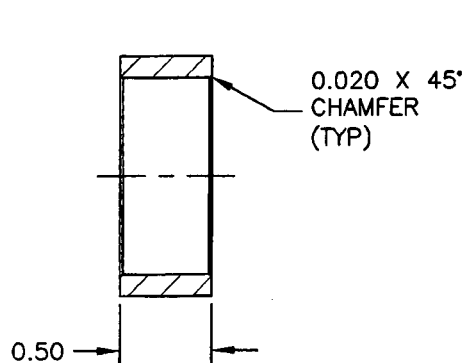


RELEASED  
07.12.07 *MP*



**SECTION A-A**

**D3330-17 HANDLE SOCKET**



**D3330-19 HANDLE RIM**

**NOTES:**

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

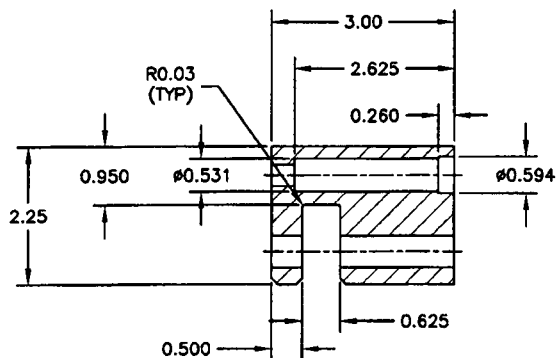
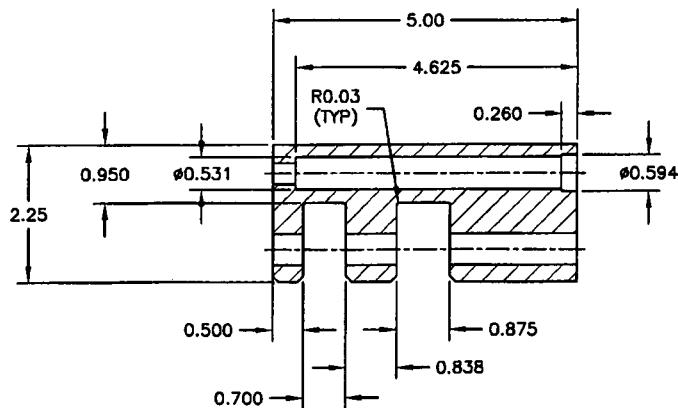
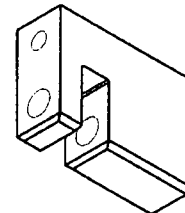
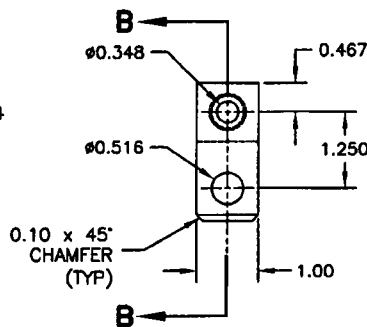
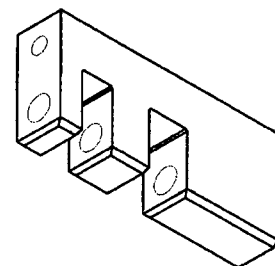
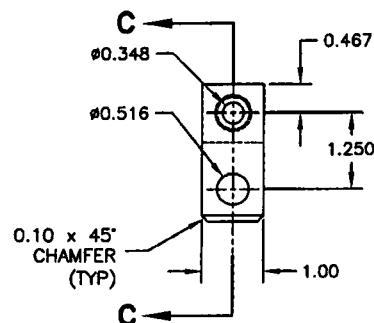
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3330	REV. D SHEET 9 OF 9
DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:3

**RELEASED**  
07.12.07 *[Signature]***SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries